## Work Order ID 53890

November 23, 2009 11:24:40 AM



Page 1

D2322 Accept Setup Start Item ID: C Revision ID: Stop Item Name: Step Spacer Start Pate: Start Qty: 20.00 23/11/2009 **Cust Item ID:** Required Date: 27/11/2009 Req'd Qty: 20.00 **Customer:** Reference: Start Run Date 27-11-23 Tooling: Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Accept Reject Reject Operation Set Up/ Draw Draw Plan Insp. Sequence ID/ Code Qty Number Stamp Rev. **Qty** Description Number Work Center ID **Run Hours** Draw Nbr **Revision Nbr** D2322 Rev C 0.00 100 FLOW WATER JET 9-13-3 0.00 Waterjet Memo 1-Cut as per Dwg D2322 Dwg Rev: \_\_\_ Drog Rev: \_\_ D2-FLOW CNC Waterjet Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 B 9-13-7 0.00 Memo Quality Control 0.00 120 QC8- Inspect parts - second check

=> 809/12/03

Quality Control

Memo

0.00

Dart Aerospac	e Ltd
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W/O:			W	ORK ORDER CHANGI	ES				••••••••••••••••••••••••••••••••••••••
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:	
		esolution:							
NCR:	i	,	WORK ORD	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		ction B Verification			Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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C

Item ID:

D2322

Accept

Setup Start

Stop

**Revision ID:** 

Item Name: Step Spacer

**Start Date:** 

Start Qty: 20.00 .03/11/2009

Req'd Qty: 20.00 Required Date: 27/11/2009

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Date:

Run

Start

 $\mathbf{v}_{1},\mathbf{v}_{2}^{\star}$ 

Stop



Sequence ID/

Work Center ID 130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Memo

Form as per Dwg D2322

Set Up/ **Run Hours** 

**SPC (Y/N):** 

0.00

0.00

Number

Draw

SB 09/12/07

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

**Quality Control** 

OC5- Inspect part completeness to step on W/O

-) Sorlizlo7

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

MD 09/12/07

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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NCR:				R NON-CONFORMA				<del>.</del> .					
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B	& Verific	cation	Approval Chief Eng	Approval QC Inspector				
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Page 3

Item ID:

D2322

Accept

Setup Start

Item Name:

**Start Date:** 

**Revision ID:** C

Step Spacer

**Required Date: 27/11/2009** 

23/11/2009

Start Qty: 20.00 Req'd Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

Draw Draw Number Rev.

Date:

Plan Code Accept Qty

Reject Qty/

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

0.00

180

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

## **Dart Aerospace Ltd**

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _		
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NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCF	R)			18	
DATE	STEP	Description of NC Corrective Action			V£			Approval	Approval	
	O.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector	
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## **Picklist Print**

November 23, 2009 11:24:47 AM

Work Order ID: 53890

Parent Item:

D2322RevC

Parent Item Name: Step Spacer

Comments:



Start Date: 23/11/2009

**Required Date: 27/11/2009** 

Page 1

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	•	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	555.4571		<b>ن</b> .		
											KB 9-11-26	·

2024-T3 .040 sheet

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		Į.
MAT	555.4570789	
110305	192	
110337	6.4	1
111786	32.0665789	
112291	50.1264	1
112331	82.8641	
113162	192	1

Dart Ae	rospace	e Ltd						•	4,		
W/O:		*	W	WORK ORDER CHANGES							
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>\</b> :	_ Date: _			
	R	esolution:	Dispositio	n:	QA: N/C C	losed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCI	₹)					
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section Section	1		QC Inspector		

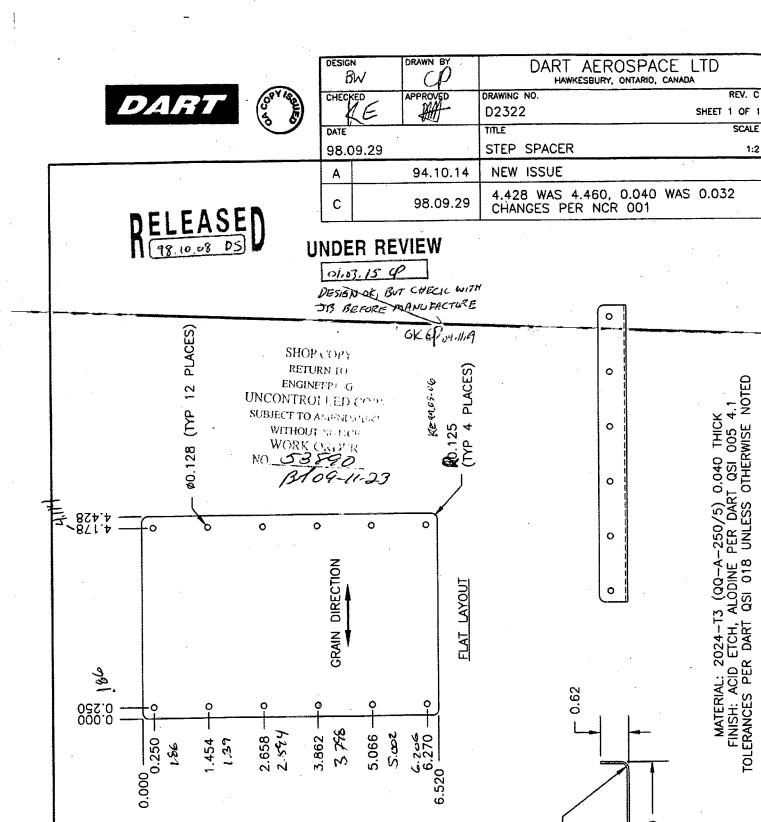
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
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DART AEROSPACE LTD	Work Order:	53890
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST  X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
0.250	+/-0.005	.252	<b>X</b>							
4.178	+/-0.005	4,179	<b>X</b>							
4.428	+/-0.010	4.437	79							
0.250	+/-0.005	753	<b>₹</b>							
6.520	+/-0.010	6.518	8							
Ø0.128	+0.005/-0.000	131	x							
R0.125	+/-0.010	.175	p							
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leasured by:	æ	Audited b	y: \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		Prototype App	oroval: N/A *				

Measured by:	Q.	Audited by:	Prototype Approval:	N/A *
Date:	4-17-7	Date: 09/12/03	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.12	New Issue	P/O D2582	KJ/JLM 🛠	141/



3.400

RO.125